



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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647.7710

Job Sheet 205072



Part No: 647.7710

Job Qty: 40 pcs

Part Name: Strut Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/27/19

Job Tracking No:

Due Date: 2/21/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A2 IPP REV:A 12.11.06 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Conventional Mill - 1	40 pcs	2/21/20	2/21/20	0.00	7.20	Conventional Mill - 1		✓ 20/1/15
							Conventional Mill - 2		
120	QC 2	40 pcs	2/21/20	2/21/20	0.00	0.00	QC 2 - 1		✓ 20/1/15
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S247748



Part: 647.7710

Job No: 205072

Serial No/Batch: S247748

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

DART Aerospace Ltd.
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CANADA
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Date: 01/15/20

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Scap

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				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	40 pcs	2/21/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 JAN 24 2020
				QC 21 - SA - 53	3-25

Part Op 110 - (Manufacture as per dwg) 1- CUT AS PER DWG 2- Mill end of tube as per dwg 3- DEBURR AS PER DWG
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 125 - (QC8- Inspect parts - second check)
 130 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NT0.500W.083	4130 Round Tube .500 X .083W	32.8000 ft (.82 ea)	110-Conventional Mill - 1	5227401

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Conventional Mill - 1	M4130NT0.500W.083	33	41	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Tube	9.750inches ± 0.005	9.755 9.745	9.748	Weight 6.8g 3/10/16
2	Strut Tube	0.500inches ± 0.005	0.505 0.495	0.500	Diameter Vern JWS
3	Strut Tube	0.334inches ± 0.005	0.339 0.329	0.334	Diameter ...
4	Strut Tube	0.188inches ± 0.005	0.193 0.183	0.188	Radius ...

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____ _____ _____					